

**PHASE CHANGE INK FORMULATION CONTAINING A COMBINATION  
OF A URETHANE RESIN, A MIXED URETHANE/UREA  
RESIN, A MONO-AMIDE AND A POLYETHYLENE WAX**

**ABSTRACT OF THE DISCLOSURE**

Phase change ink carrier compositions comprising an admixture of (1) at least one urethane resin; and/or (2) at least one mixed urethane/urea resin; and/or (3) at least one mono-amide; and/or (4) at least one polyethylene wax are provided. In addition, a phase change colored ink of such carrier compositions comprising a phase change ink compatible colorant are also provided. Embodiments of the present invention also include methods for producing a layer of the above phase change colored ink on the surface of a substrate by either direct or indirect printing. Such methods also encompassing using a polyethylene wax as an overcoat layer above such a phase change ink layer on a printed substrate.